

Date: Friday, 11/07/2008 10:24:25 AM
 User: Julie Lecocq

Process Sheet

| | |
|--|--|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : 206B UTILITY BASKET |
| Job Number : 40434 | |
| Estimate Number : 11282 | |
| P.O. Number : | Part Number : D206540013 |
| This Issue : 11/07/2008 S.O. No. : | Drawing Number : D206-540 /DSI9361 |
| Prsht Rev. : NC | Project Number : N/A |
| First Issue : / / Type : LARGE FAB ASSY | Drawing Revision : I / A |
| Previous Run : 40149 | Material : |
| Written By : | Due Date : 29/08/2008 Qty: 1 Um: Each |
| Checked & Approved By : <u>JUL 08.7.11</u> | |
| Comment : Est Rev:I Revised as per Rev I 05-12-07 JLM Est Rev:J reformat 06.04.04 EC Est Rev:K 07-03-20 As per DSI9361 JLM | |

Additional Product

Job Number:



| | | |
|----------------|------------------------------|----------------------|
| Seq. #: | Machine Or Operation: | Description : |
|----------------|------------------------------|----------------------|

| | | |
|-----|----|------------------|
| 1.0 | DC | DOCUMENT CONTROL |
|-----|----|------------------|



Comment: DOCUMENT CONTROL
 Photocopy bluefile & type labels per PPPD206-540-013 CHG005

8/08/31

| | | |
|-----|-------------|-----------------------|
| 2.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
|-----|-------------|-----------------------|



Comment: PACKAGING RESOURCE #1
 Pick: Assembly Kit

| | | |
|-----|--------|--------------------------------|
| 3.0 | 40434A | 206B BASKET LID - UNDER REVIEW |
|-----|--------|--------------------------------|



Comment: Sub-Component 206B BASKET LID
 1 x D2330-043 Batch

40434A

8/08/31

| | | |
|-----|--------|---------------------------------|
| 4.0 | 40434B | 206B BASKET BASE - UNDER REVIEW |
|-----|--------|---------------------------------|



Comment: Sub-Component 206B BASKET BASE
 1 x D2330-041 Batch

40434B

8/08/31

| | | |
|-----|----------|------------------------------|
| 5.0 | D2332041 | Lid Prop Assembly 6.69" long |
|-----|----------|------------------------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1 D2332-041 Prop Ass'y *1338792*

8/7/29

SP

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Job Number: 40434

Part Number: D206540013

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D2022101

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 D2022-101 SPACER B37521

SO

7.0

D2530

Handle Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1 D2530 Handle Weldment B40211

SP

8.0

D2535

Spring



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 D2535 Spring B37071

SP

9.0

D2537

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 D2537 Bushing B39153

SP

10.0

D2931

Bumper



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 D2931 Bumper B21139

SP

11.0

MS20600AD4W3

Cherry Rivets



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 MS20600AD4W3 Rivet M18071

8/7/29

SP

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| | | |
|------|-------|------|
| 12.0 | AN47A | Bolt |
|------|-------|------|



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 AN4-7A Bolt M16199

SP

| | | |
|------|--------|------|
| 13.0 | AN424A | Bolt |
|------|--------|------|



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1 AN4-24A Bolt M104547

SP

| | | |
|------|--------|------|
| 14.0 | AN316A | Bolt |
|------|--------|------|



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 AN3-16A Bolt M107737

SP

| | | |
|------|--------|-------------------------|
| 15.0 | D27283 | Dart Logo Label - large |
|------|--------|-------------------------|



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Dart Logo label large

Batch: M22553

SP

| | | |
|------|--------|------|
| 16.0 | AN422A | Bolt |
|------|--------|------|



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1 AN4-22A Bolt M107715

SP

| | | |
|------|--------|------|
| 17.0 | AN517A | Bolt |
|------|--------|------|



(4)

Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 AN5-17A Bolt M108205

8/7/29

SP

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Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

AN960JD416

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch
4 AN960JD416 Washer M107939

sq

19.0

AN960JD416L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Washer

M108138

sq

20.0

AN960JD516

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch
4 AN960JD516 Washer M107959

sq

21.0

AN9704

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch
4 AN970-4 Washer M108377

sq

22.0

AN960JD8

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch
4 AN960JD8 Washer M107650

sq

23.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch
2 MS21042L3 Nut (or -3) M107665

8/7/29

sq

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Job Number:



Seq. #:

Machine Or Operation:

Description :

24.0

MS21042L4

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

4 MS21042L4

Nut (or -4)

M107478

sq

25.0

MS21042L5

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

4 MS21042L5

Nut (or -5)

M107939

sq

26.0

D2258170

Label - 170 lb



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2258-170

Placard

40487

8/7/29

sq

27.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D206-540

8/08/07/31 @

28.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8/08/07/31 (+)

29.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick: Packing Kit

30.0

D2249041

Fitting Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Packing Kit

2 D2249-041

Braket

B40486

8/7/29

sq

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|---------|-----------------------|---------------|

| | | |
|------|--------|--------|
| 31.0 | D33963 | Spacer |
|------|--------|--------|



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Spacer

Batch: B334334

50

| | | |
|------|----------|--------|
| 32.0 | D2022101 | Spacer |
|------|----------|--------|



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

4 D2022-101 Spacer

B337521

50

| | | |
|------|----------|--------|
| 33.0 | D2012107 | Clevis |
|------|----------|--------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

1 D2012-107 Clevis

B33585

50

| | | |
|------|-------|-------|
| 34.0 | D2259 | Label |
|------|-------|-------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

1 D2259 Placard

B10671

50

| | | |
|------|-------|--------|
| 35.0 | D2525 | Spacer |
|------|-------|--------|



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

2 D2525 Spacer kit

B345040

50

| | | |
|------|-------|---------|
| 36.0 | D2526 | Bushing |
|------|-------|---------|



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

2 D2526 Bushing

B27555

30

| | | |
|------|-------|--------|
| 37.0 | D2748 | Clevis |
|------|-------|--------|



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

2 D2748 Clevis

B34571

8/7/29

50

| W/O: | | WORK ORDER CHANGES | | | | | |
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Part Number: D206540013

Job Number:



Seq. #:

Machine Or Operation:

Description :

38.0

D27491

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: Packing Kit

1 D2749-1 Strut

B23423

SP

39.0

D27493

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: Packing Kit

1 D2749-3 Strut

B23424

SP

40.0

D2814

Strut



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Packing Kit

2 D2814 Strut

B38779

SP

41.0

AN412A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

2 AN4-12A

Bolt

M105143

SP

42.0

AN412

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Packing Kit

2 AN4-12 Bolt

M105143

SP

43.0

AN45A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick: Packing Kit

8 AN4-5A Bolt

M106605

8/7/29

SP

| W/O: | | WORK ORDER CHANGES | | | | | |
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Seq. #:

Machine Or Operation:

Description :

44.0

AN517A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Packing Kit

2 AN5-17A Bolt

M108205

sq

45.0

AN421A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Packing Kit

2 AN4-21A Bolt

M11695

sq

46.0

AN960JD416

Washer



Comment: Qty.: 19.0000 Each(s)/Unit Total: 19.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

19 AN960JD416 Washer

M107939

sq

47.0

AN960JD516

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Packing Kit

2 AN960JD516 Washer

M107959

sq

48.0

AN9704

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: Packing Kit

1 AN970-4 Washer

M108377

sq

49.0

MS21042L4

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 MS21042L4 Nut (or -4)

M107478

8/7/29

(1X)

sq

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
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Seq. #: Machine Or Operation: Description :

50.0 MS21042L5 Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Packing Kit

2 MS21042L5 Nut

M107939

SP

51.0 MS27039411 Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: Packing Kit

1 MS27039-4-11 Screw

M3355

SP

52.0 AN46 Bolts



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: Packing Kit

1 AN4-6 Bolt

M107534 9599

SP

53.0 AN3204 Nut



Comment: Qty.: 3.0000 Each(s)/Unit Total: 3.0000 Each(s)

Pick: Packing Kit

3 AN320-4 Nut

M7195

SP

54.0 AN38022 Cotter Pins



Comment: Qty.: 3.0000 Each(s)/Unit Total: 3.0000 Each(s)

Pick: Packing Kit

3 AN380-2-2 Cotter pin

M16895

8/7/29

SP

55.0 QC4 INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

8/8/11 @

56.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-540-013

Location: _____

PPP Rev: H

8/7/31

SP

| W/O: | | WORK ORDER CHANGES | | | | | |
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Seq. #:

Machine Or Operation:

Description :

57.0

QC21

FINAL INSPECTION/W/O RELEASE



08/07/31 JG

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-07-31

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

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| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D206-540 | REV. 1 SHEET 1 OF 8 |
| DATE 05.11.10 | | TITLE UTILITY BASKET INSTALLATION | SCALE NTS |
| C | 94.07.28 | REVISED DRAWING | |
| D | 94.11.12 | ADDED D2323 STRUT | |
| E | 94.11.12 | CHANGED SECTION C-C | |
| F | 94.11.12 | ADDED HANDLE AND LID PROP | |
| G | 99.09.21 | REDRAW, CHANGE LATCH/HINGE/STRUTS | |
| H | 99.12.02 | INCORPORATE DSI 9174 / DEO 9167 | |
| I | 05.11.10 | REPLACED PIANO HINGE SYSTEM | |

| Qty -011 | Qty -013 | Part No. | Description |
|-------------|-------------|--------------|-------------------------------------|
| X | | D206-540-011 | BASKET INSTL'N - BELL 206L/L1/L3/L4 |
| | X | D206-540-013 | BASKET INSTL'N - BELL 206A/B |
| | 1 | D2012-107 | CLEVIS |
| 2 | 6 | D2022-101 | SPACER |
| 2 | 2 | D2249-041 | BRACKET |
| 1 | | D2252-041 | BASKET ASSEMBLY |
| 1 | | D2252-043 | LID ASSEMBLY |
| 1 | 1 | D2258-170 | PLACARD |
| 1 | 1 | D2259 | PLACARD* |
| | 1 | D2330-041 | BASKET ASSEMBLY |
| | 1 | D2330-043 | LID ASSEMBLY |
| 1 | 1 | D2332-041 | LID PROP ASSEMBLY |
| 2 | 2 | D2525 | SPACER KIT |
| 2 | 2 | D2526 | BUSHING |
| 1 | 1 | D2530 | HANDLE WELDMENT |
| 2 | 2 | D2535 | SPRING |
| 2 | 2 | D2537 | BUSHING |
| 2 | 2 | D2748 | CLEVIS |
| | 1 | D2749-1 | STRUT |
| | 1 | D2749-3 | STRUT |
| 1 | | D2749-5 | STRUT |
| 1 | | D2749-7 | STRUT |
| | 2 | D2814 | STRUT |
| 4 | 4 | D2931 | BUMPER |
| 2 | 2 | AN3-16A | BOLT |
| | 3 | AN320-4 | NUT |
| | 3 | AN380-2-2 | COTTER PIN |
| | 2 | AN4-12 | BOLT |
| 2 | 2 | AN4-12A | BOLT |
| 2 | 2 | AN4-21A | BOLT |
| 1 | 1 | AN4-22A | BOLT |
| 1 | 1 | AN4-24A | BOLT |
| 8 | 8 | AN4-5A | BOLT |
| | 1 | AN4-6 | BOLT |
| 2 | 2 | AN4-7A | BOLT |
| 6 | 6 | AN5-17A | BOLT |
| 16 | 23 | AN960JD416 | WASHER |
| 6 | 6 | AN960JD516 | WASHER |
| 4 | 4 | AN960JD8 | WASHER |
| 4 | 5 | AN970-4 | WASHER |
| 4 | 4 | MS20600AD4W3 | RIVET |
| 2 | 2 | MS21042L3 | NUT (OR MS21042-3) |
| 8 | 8 | MS21042L4 | NUT (OR MS21042-4) |
| 6 | 6 | MS21042L5 | NUT (OR MS21042-5) |
| | 1 | MS27039-4-11 | SCREW |

*NOTE: Placard D2259 to be installed in cock pit near the airspeed indicator.

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Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries



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| DESIGN KE | DRAWN BY MB | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED [Signature] | APPROVED [Signature] | DRAWING NO. D206-540 | REV. 1 SHEET 2 OF 8 |
| DATE 05.11.10 | | TITLE UTILITY BASKET INSTALLATION | SCALE NTS |

WEIGHT AND BALANCE

| Installation | Weight | LATERAL | | LONGITUDINAL | |
|------------------------------------|---------|---------|------------|--------------|------------|
| | | Arm | Moment | Arm | Moment |
| D206-540-011 | 70 lb | 40.0 in | 2800 in-lb | 111.0 in | 7770 in-lb |
| 206 L Series Basket Installation | 31.8 kg | 1.0 m | 31.8 m-kg | 2.8 m | 89.0 m-kg |
| D206-540-013 | 50 lb | 40.0 in | 2000 in-lb | 99.0 in | 4950 in-lb |
| 206 A/B Series Basket Installation | 22.7 kg | 1.0 m | 22.7 m-kg | 2.5 m | 56.8 m-kg |

GENERAL NOTES

COMPATIBILITY

Compatibility of this installation with the aircraft is the **responsibility of the installer**. Ensure that this installation does not conflict with a previous modification. This basket can only be installed on the starboard side of the aircraft on high gear. Ensure that any steps that are outboard of the crosstubes are removed.

WORKMANSHIP

Unless otherwise stated, all workmanship should be to the standard set by the Aircraft Maintenance Manual.

CONTINUING AIRWORTHINESS

This installation should be maintained in accordance with the Maintenance Manual Supplement MMS-D206-540.

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|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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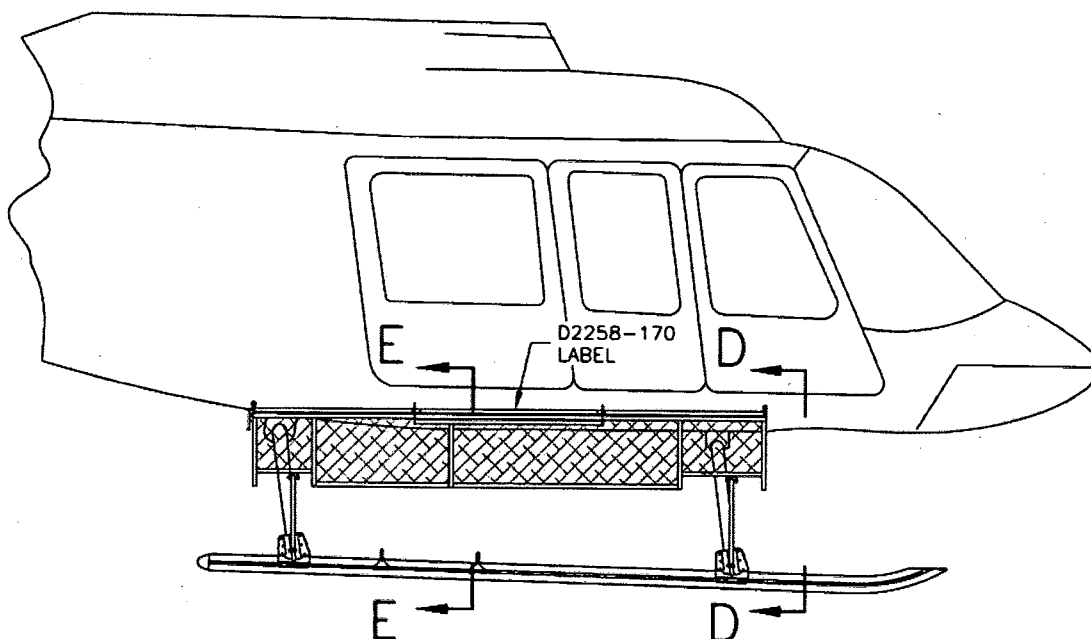
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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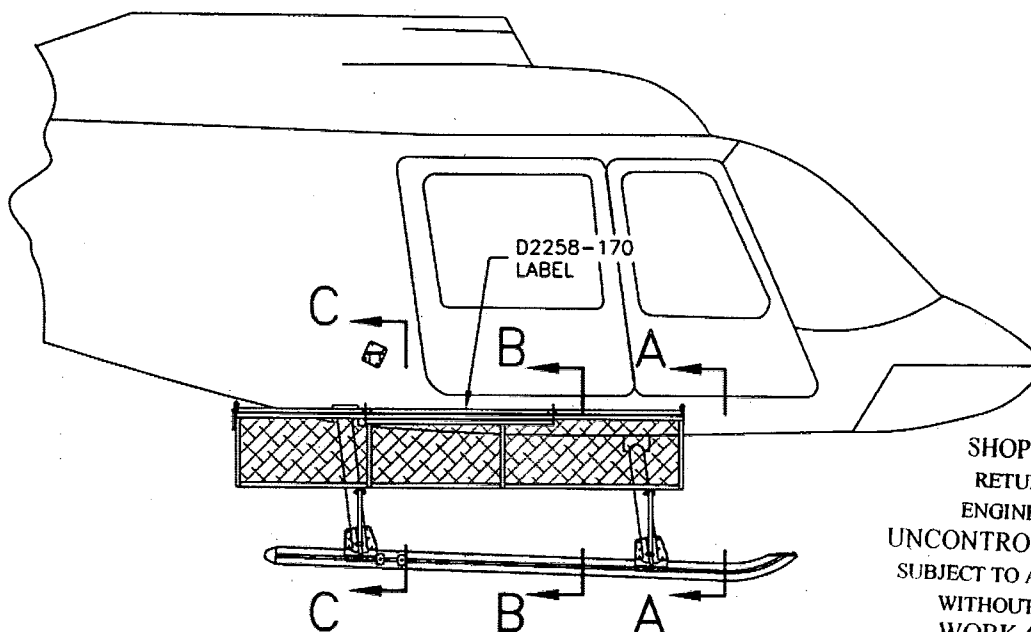
NOTE: Date & initial all entries



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| CHECKED [Signature] | APPROVED [Signature] | DRAWING NO. D206-540 | REV. 1 SHEET 3 OF 8 |
| DATE 05.11.10 | | TITLE UTILITY BASKET INSTALLATION | SCALE NTS |



D206-540-011 206L/L1/L3/L4 BASKET INSTALLATION



D206-540-013 206A/B BASKET INSTALLATION

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| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

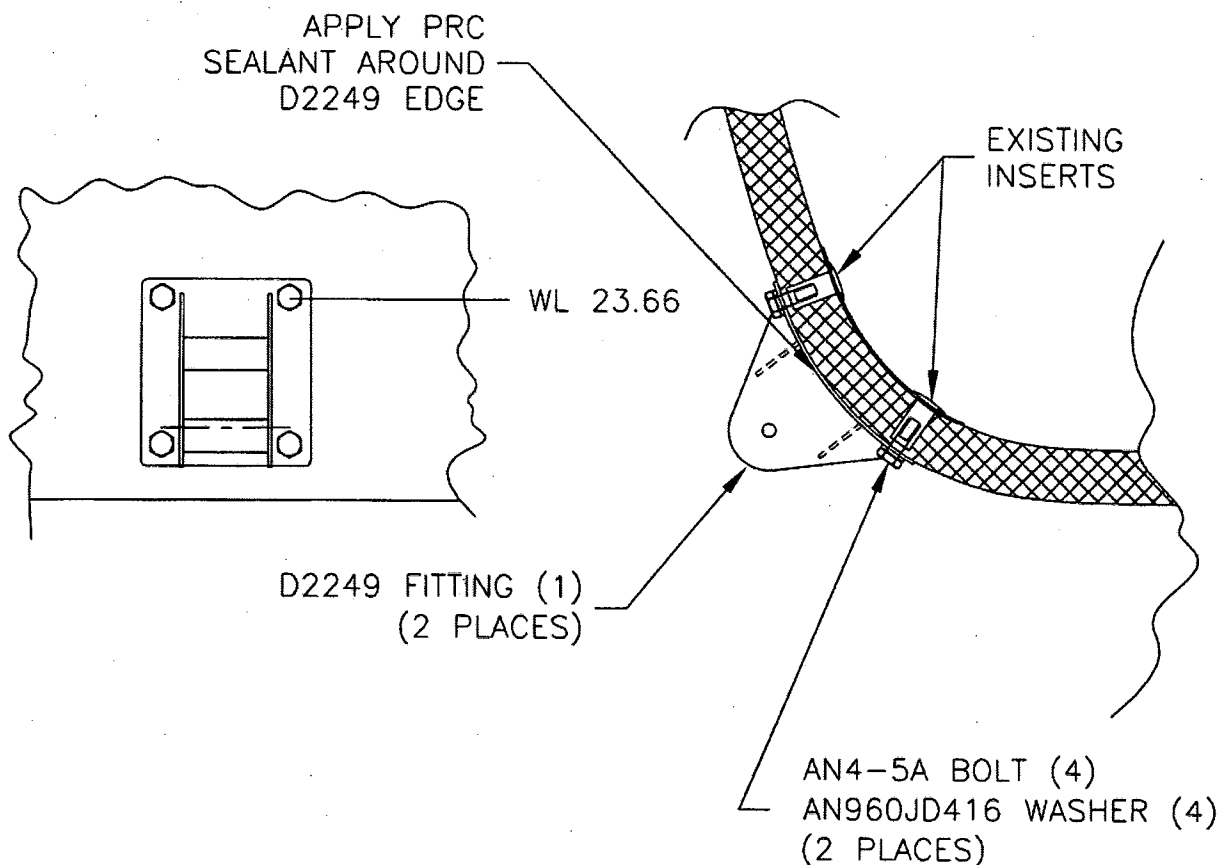
QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D206-540 | REV. 1 SHEET 4 OF 8 |
| DATE 05.11.10 | TITLE UTILITY BASKET INSTALLATION | | SCALE NTS |



BRACKET DETAIL

REPLACE 206-031-370-6
AND 206-031-370-8 STEPS AS
REQUIRED WITH D2249 FITTINGS.
REFER TO SERVICE INSTRUCTION
BHT-206-SI-22

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| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

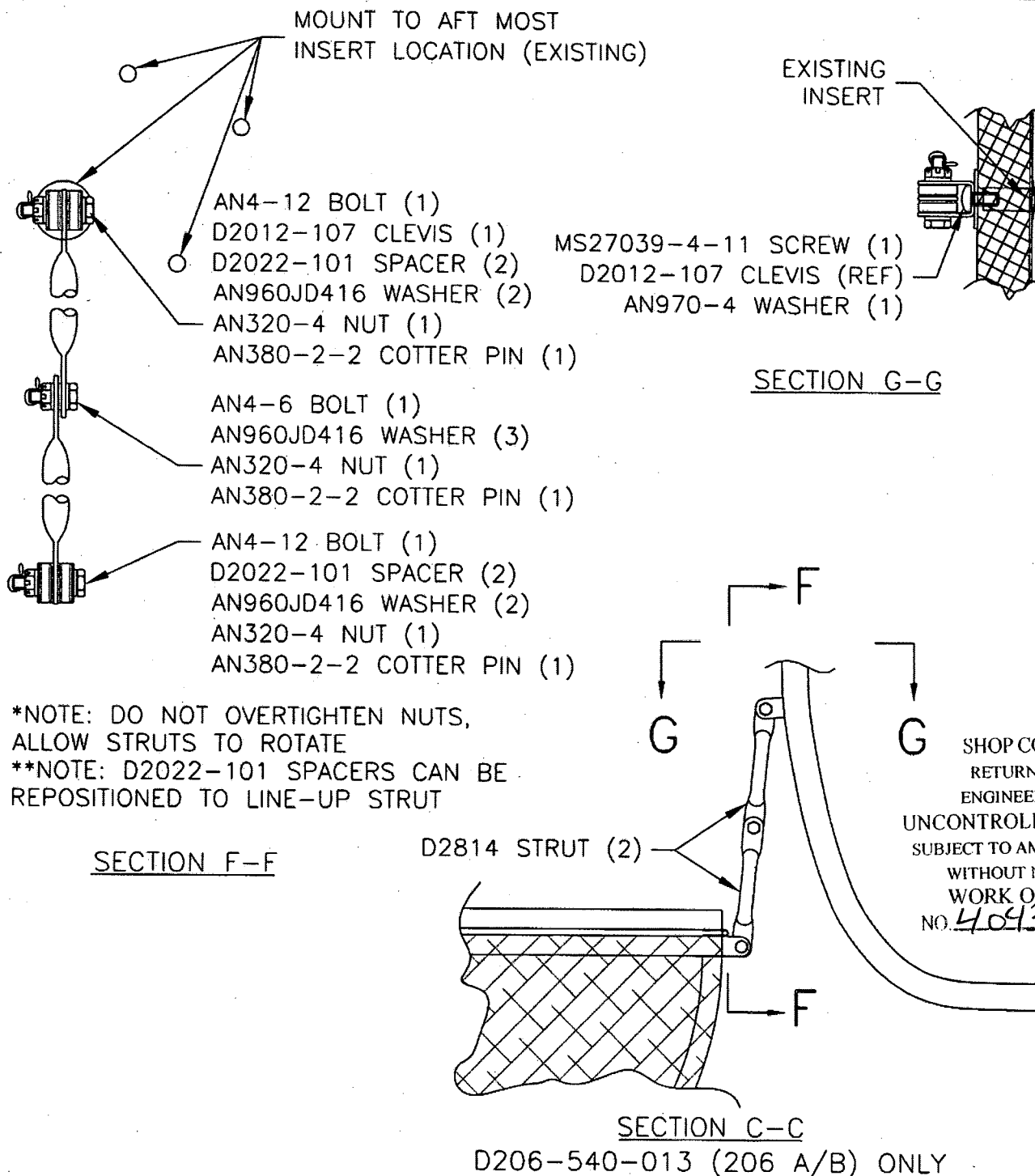
QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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| DATE 05.11.10 | | TITLE UTILITY BASKET INSTALLATION | SCALE NTS |



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| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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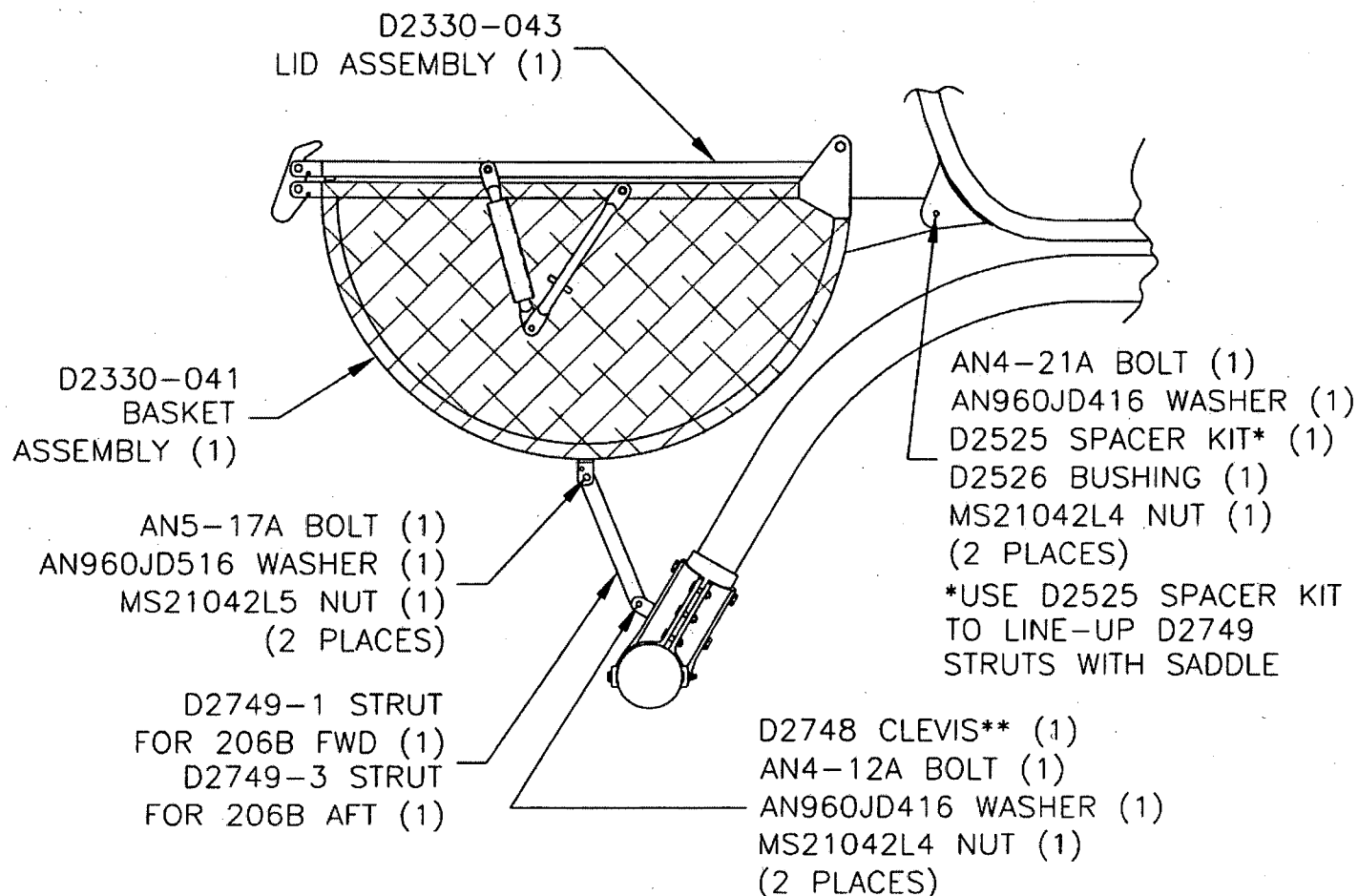
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| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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| MB | MB | D206-540 | SHEET 6 OF 8 |
| DATE | TITLE | SCALE | |
| 05.11.10 | UTILITY BASKET INSTALLATION | NTS | |



**NOTE: REPLACE EXISTING SADDLE WASHER WITH D2748
CLEVIS AND RE-ATTACH USING EXISTING SADDLE HARDWARE

SECTION A-A AND B-B

D206-540-013 (206 A/B) ONLY

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| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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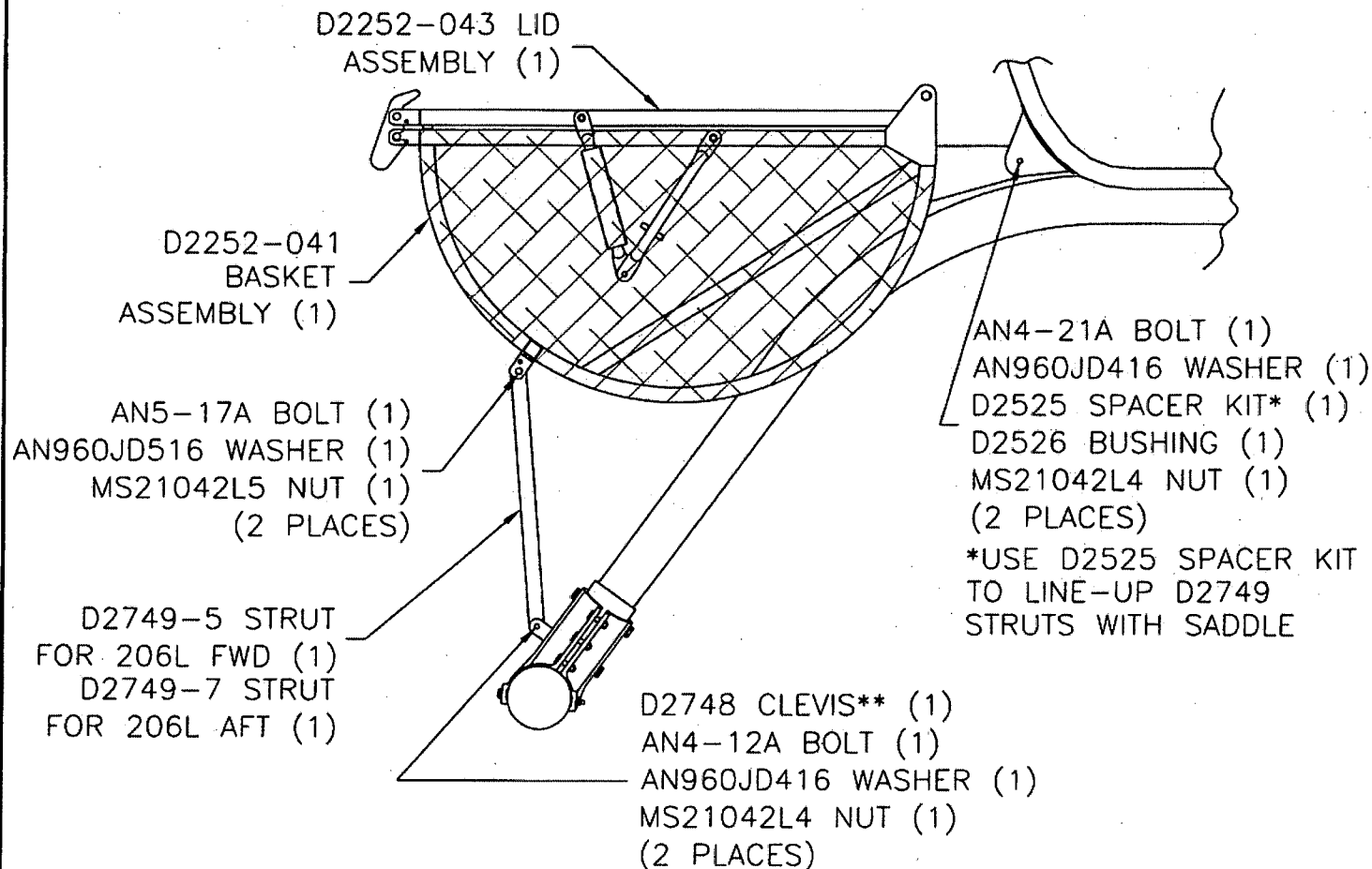
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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| CHECKED | APPROVED | DRAWING NO. | REV. 1 |
| | | D206-540 | SHEET 7 OF 8 |
| DATE | TITLE | SCALE | |
| 05.11.10 | UTILITY BASKET INSTALLATION | NTS | |



**NOTE: REPLACE EXISTING SADDLE WASHER WITH D2748 CLEVIS AND RE-ATTACH USING EXISTING SADDLE HARDWARE

SECTION D-D AND E-E

D206-540-011 (206 L/L1/L3/L4) ONLY

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| W/O: | | WORK ORDER CHANGES | | | | | |
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| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

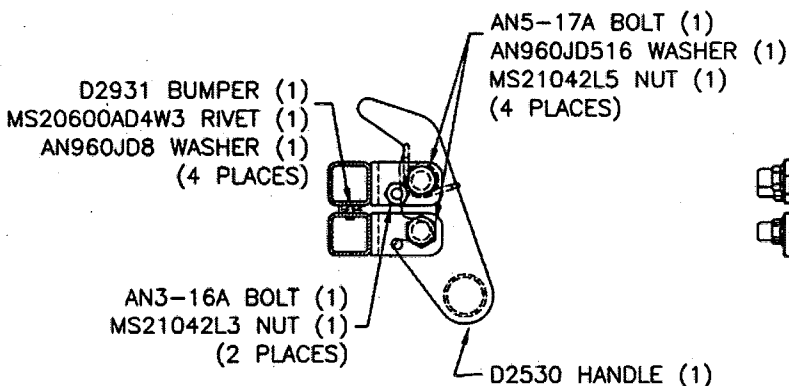
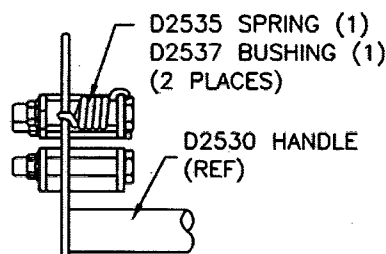
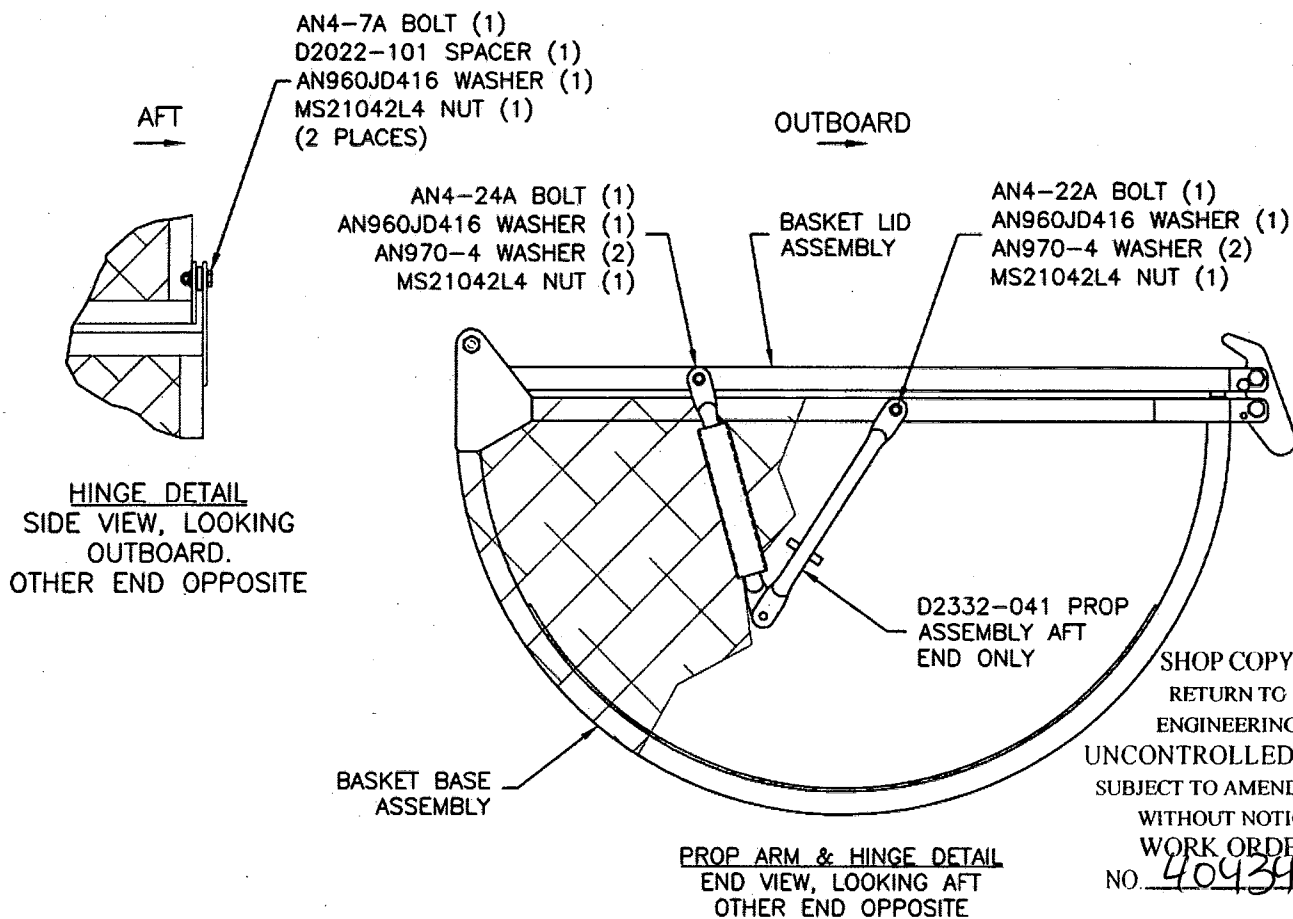
QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
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| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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| DATE 07.03.15 | | TITLE UTILITY BASKET SPACER | SCALE NTS |
| A | 07.03.15 | NEW ISSUE | |

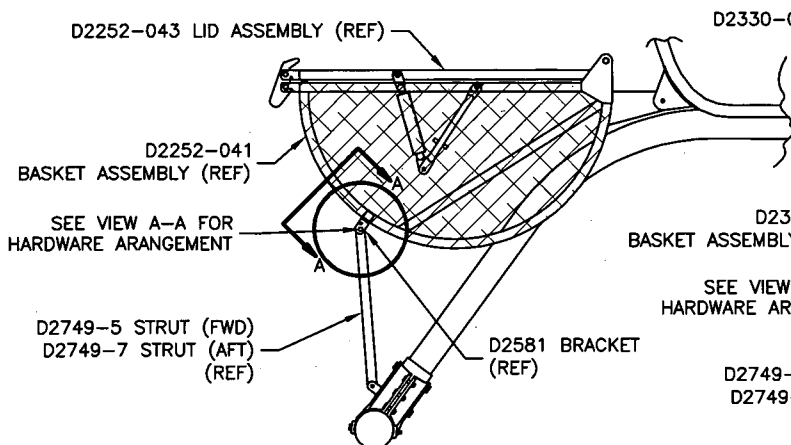
DART SERVICE INSTRUCTION

TO AMEND DART INSTALLATION DRAWING D206-540 REV. I
REF. CANADIAN STC: SH94-5
REF. FAA STC: SR00386NY

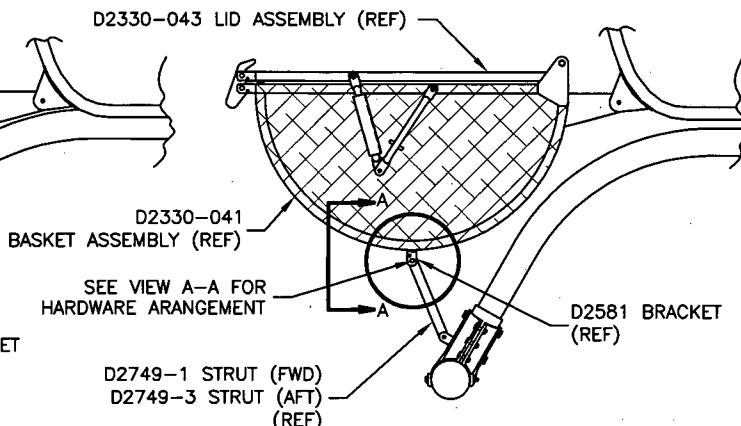
The following parts will be added to the Parts List on page 1 of Installation Drawing D206-540.

| Qty - 011 | Qty - 013 | Part No. | Description |
|-----------|-----------|--------------|-------------------------------------|
| X | | D206-540-011 | BASKET INSTL'N - BELL 206L/L1/L3/L4 |
| | X | D206-540-013 | BASKET INSTL'N - BELL 206A/B |
| 4 | 4 | D3396-3 | SPACER |

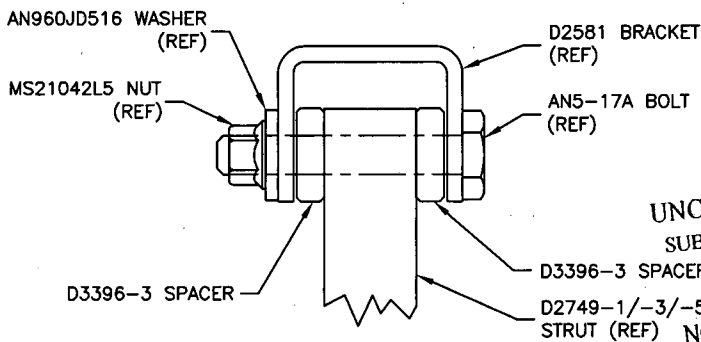
Install qty(2) D3396-3 Spacers per strut at the location shown in **Figure 1** (for D206-540-011 kit) and **Figure 2** (for D206-540-013 kit). Install hardware per View A-A



**FIGURE 1 - D206-540-011
INSTALLATION**



**FIGURE 2 - D206-540-013
INSTALLATION**



**VIEW A-A - HARDWARE
ARRANGEMENT (TYP)**

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DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 07.03.15
CERT. NO.: SH94-5
ISSUE NO.: 4

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|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Date: Friday, 11/07/2008 10:24:47 AM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 206B BASKET BASE - UNDER REVIEW
 Job Number : 40434B # 01.07.11
 Estimate Number : 11276
 P.O. Number : Part Number : D2330041
 This Issue : 11/07/2008 S.O. No. : Drawing Number : D2330 REVE
 Prsht Rev. : NC Project Number : N/A
 First Issue : / / Type : LARGE FAB ASSY Drawing Revision : E
 Previous Run : 40149B Material :
 Written By : Due Date : 29/08/2008 Qty: 1 Um: Each
 Checked & Approved By : JUD 08.7.11
 Comment : Est Rev:H 02.09.04 M304EX0.75-16F was M750-16FXS-S/S K
 J

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D31661 Basket Hoop



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part# Description Batch

4 D3166-1 Hoop B40090

SAD 08/07/28 ②

2.0 M304TS0750W065 304 SQ Tube.75x.75x.065W



Comment: Qty.: 26.3970 f(s)/Unit Total : 26.3970 f(s)

3/4" x 3/4" x 0.063 wall 304/316 SS tubing.

Batch: M102550

SAD 08/07/28 ①

3.0 LARGE FAB 1 0-055 # 01.07.11 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut Rib from 3/4" x 3/4" x 0.063 wall 304/316 SS tubing.

Cut 4 D2235-1 From D3166-1

2- Cut D2330-1-3-5-7-9 as per Dwg D2330

3-Drill hole in D2330-3 as per Dwg D2330

4-Deburr

SAD 08/07/28 ①

4.0 D22531 Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Gusset

Batch: B35685

Ppl 08-07-28

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Friday, 11/07/2008 10:24:47 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B BASKET BASE - UNDER REVIEW

Job Number: 40434B

Part Number: D2330041

Job Number:



Seq. #: Machine Or Operation: Description :

5.0 D2012107 Clevis



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:



Qty Part Number Description Batch

1 D2012-107 Clevis

B33555

Pl 08.07.28

6.0 D23273 Spacer Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:



Qty Part Number Description Batch

1 D2327-3 Bushing

B37541

Pl 08.07.28

7.0 D2581 Mounting Bracket



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:



Qty Part Number Description Batch

4 D2581 Mounting Channel

B40086

Pl 08.07.28

8.0 D2254 Gusset



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:



Qty Part Number Description Batch

2 D2254 Lug

B23421

Pl 08.07.28

9.0 D22323 Basket Hinge



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:



Qty Part Number Description Batch

2 D2232-3 HINGE

B39384

Pl 08.07.28

10.0 M304EX07516F Expanded Metal Flat Stai



Comment: Qty.: 31.5000 sf(s)/Unit Total : 31.5000 sf(s)

Pick:

Qty Part Number Description Batch

30 sf M304EX0.75-16F Expanded Metal

M108152 (2)
M168474

SAD 08/07/28

①

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Friday, 11/07/2008 10:24:47 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B BASKET BASE - UNDER REVIEW

Job Number: 40434B

Part Number: D2330041

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld as per Dwg D2330 using Welding Table and corner JigDeburr as required

A/R SS ROD

Batch: M107051

SL 08/07/29
CP 08.07.29

12.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

ID 08-07-30 (1)

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/07/30 (10)

14.0

POWDER COATING

POWDER COATING



M108523



(12)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

2:00
400 °C
2:30

M.F. 08/07/30

15.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FS 08/07/30 (B)

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *G-A*

CP 08/07/31 (2)

17.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/07/31 (A)

Job Completion



MF 08-07-31

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

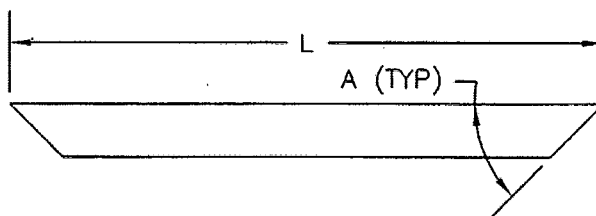
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|-------------------------------|--------------------------------|--|-------------------------------|
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| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D2330 | REV. E SHEET 1 OF 5 |
| DATE 05.11.10 | | TITLE BASKET ASSEMBLY (206B) | SCALE NTS |
| C | 96.05.23 | ADDED LATCH AND LABEL PLATE | |
| D | 99.09.14 | MODIFIED LATCH, REDREW | |
| E | 05.11.10 | D2253-1 WAS D2253 (NCR 533), ADDED MEMBERS TO LID FRAME, ADDED D2232-1/-3 & D2330-11 | |

| Qty -041 | Qty -043 | Part Number | Description | L | A |
|-------------|-------------|-------------|------------------------|-------|----|
| X | | D2330-041 | BASKET ASSEMBLY | | |
| | X | D2330-043 | LID ASSEMBLY | | |
| | | | | | |
| 1 | | D2012-107 | CLEVIS | | |
| 4 | | D2235-1 | RIB | | |
| | 2 | D2232-1 | HINGE | | |
| 2 | | D2232-3 | HINGE | | |
| 2 | | D2330-1 | FRAME | 84.00 | 45 |
| 2 | 2 | D2330-3 | FRAME | 25.50 | 45 |
| 1 | | D2330-5 | FRAME | 32.75 | 90 |
| 1 | | D2330-7 | FRAME | 24.25 | 90 |
| 1 | 2 | D2330-9 | FRAME | 24.00 | 90 |
| | 2 | D2330-11 | FRAME | 83.27 | 45 |
| | 2 | D2330-13 | FRAME | 23.63 | 90 |
| | 1 | D2330-15 | FRAME | 33.00 | 90 |
| 2 | | D2253-1 | LUG | | |
| 2 | | D2254 | GUSSET | | |
| | 1 | D2327-1 | BUSHING | | |
| 1 | | D2327-3 | BUSHING | | |
| | 1 | D2329 | LABEL PLATE | | |
| 4 | 2 | D2581 | MOUNTING CHANNEL | | |
| A/R | A/R | | 3/4-16F EXPANDED METAL | | |

NOTES:

- MATERIAL: AISI 304/316 SS 3/4 X 3/4 X 0.060 WALL SQUARE TUBE
(REF. DART SPEC. M304TS0.075W/0.060)
- FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
- WELD PER DART QSI 004
- ALL DIMENSION ARE IN INCHES
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

**CUT SIZE DETAIL**

UNDER REVIEW
08.02.06
TUBE TO BE
CHANGED TO 0.065
WALL

RELEASED
05.11.26

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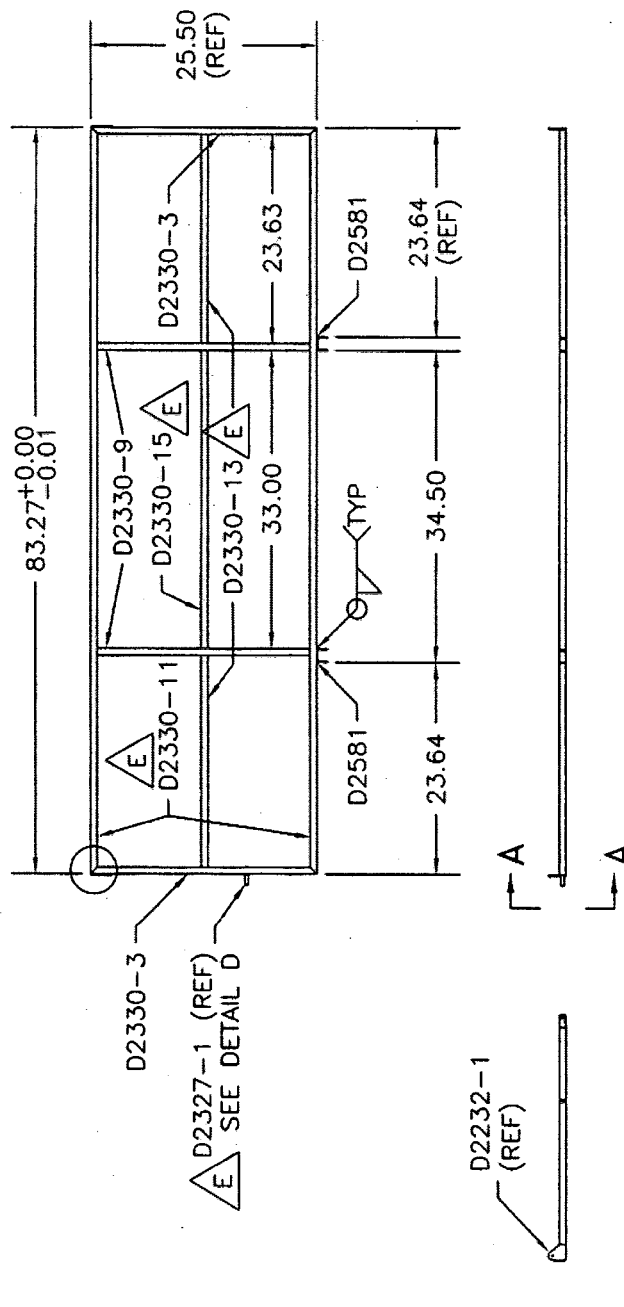


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| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D2330 | REV. E SHEET 2 OF 5 |
| DATE 05.11.10 | TITLE BASKET ASSEMBLY (206B) | | SCALE NTS |

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05.11.26

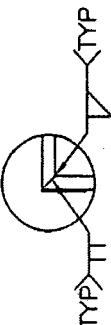
UNDER REVIEW
08.06.05

TUBING TO BE
CHANGED TO 0.065
WALL
08.07.11



D2330-043 LID FRAME

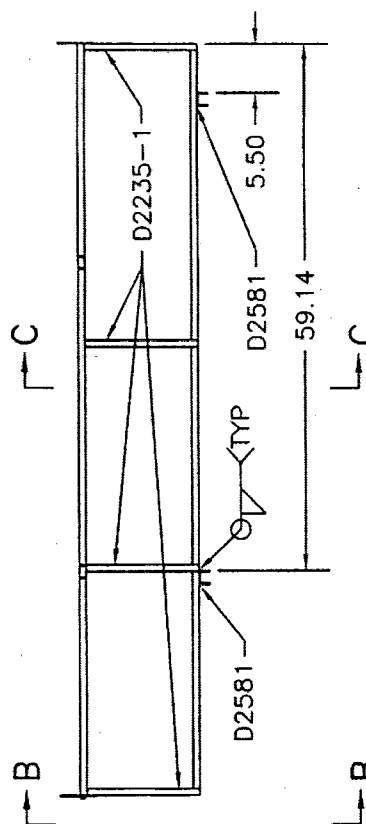
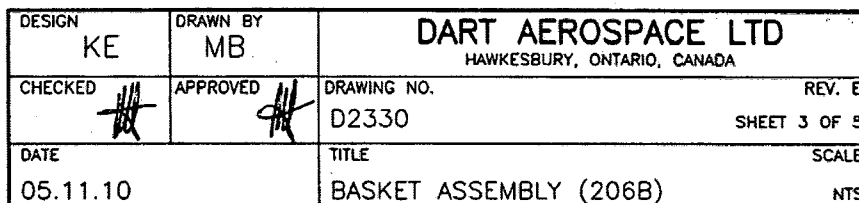
WELD ALL JOINTS
AS SHOWN



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02330-041 BASKET FRAME

WELD ALL JOINTS
AS SHOWN

D2327-3 (REF)
SEE DETAIL D

RELEASED
05/11/26

PD 06.07.11
UNDER REVIEW

~~TUBING TO BE
CHANGED TO C-005
WALL~~

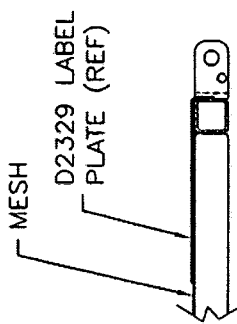
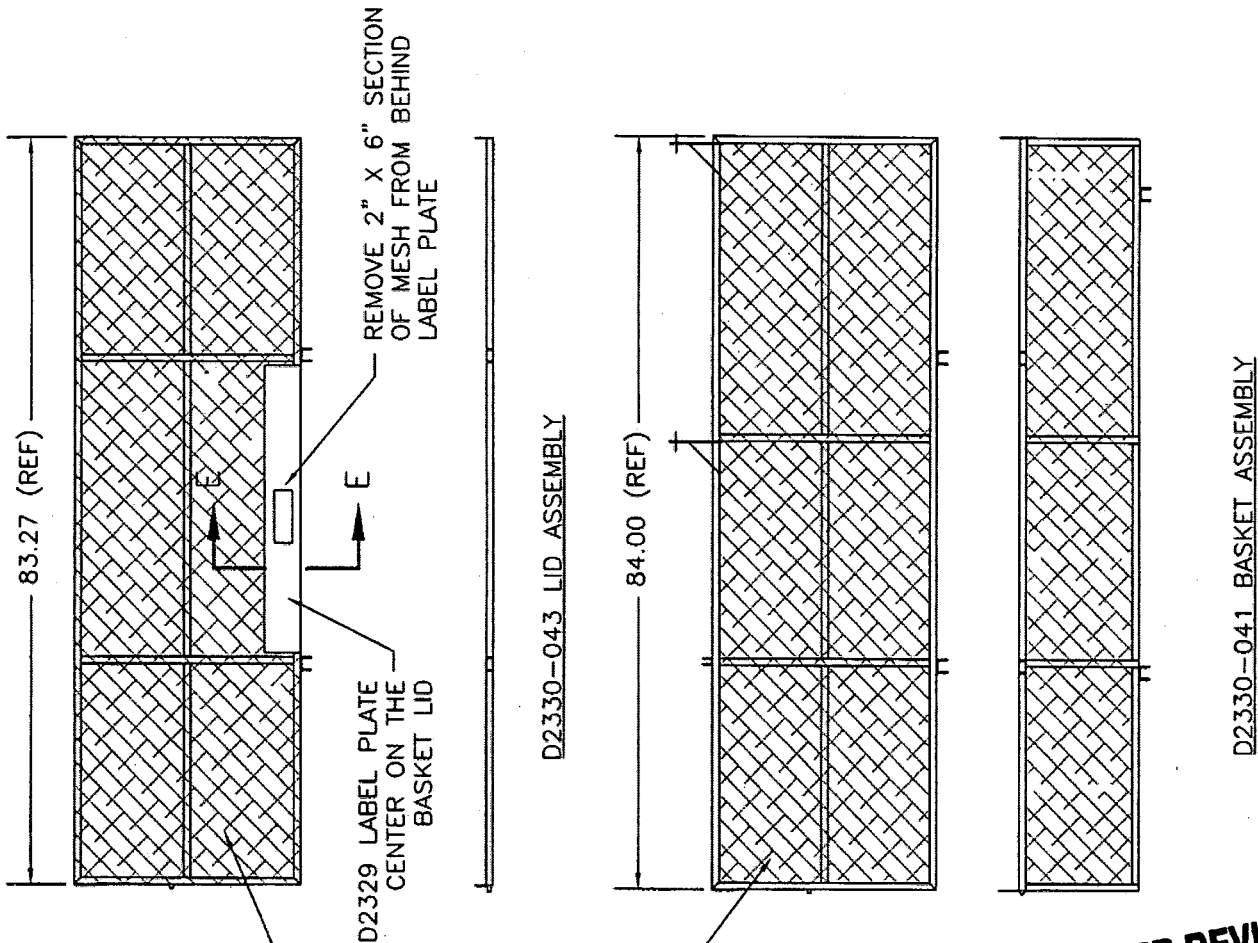
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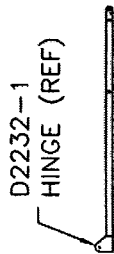
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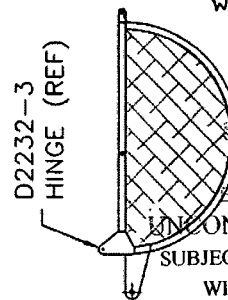
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| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D2330 | REV. E SHEET 4 OF 5 |
| DATE 05.11.10 | TITLE BASKET ASSEMBLY (206B) | | SCALE NTS |



SECTION E-E



SKIN WITH 3/4-16 F
EXPANDED SS, TACK
WELD EACH STRAND
END TO FRAME



UNDER REVIEW

08.02.05 *[Signature]*
TUBING TO BE
CHANGED TO 0.065
WALL
08.07.11

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WITHOUT NOTICE
WORK ORDER
NO. 40434B

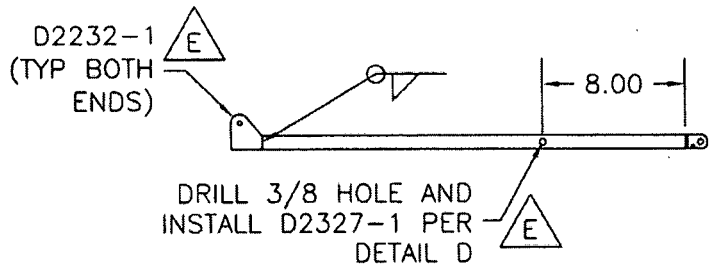
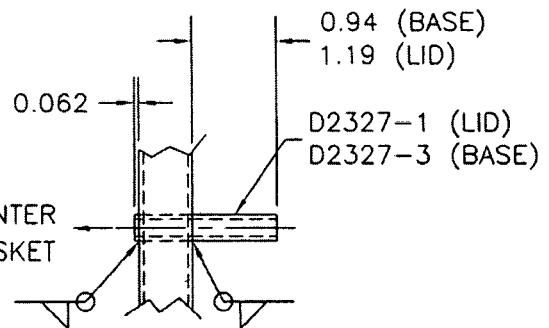
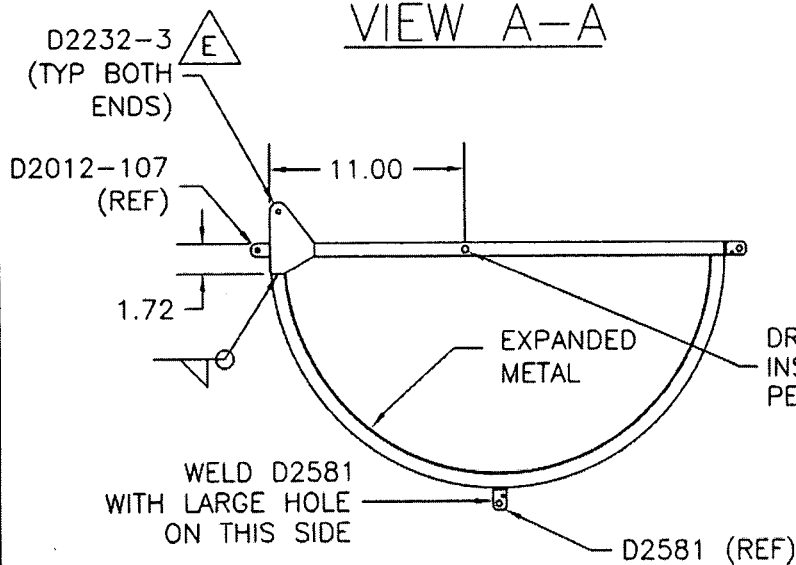
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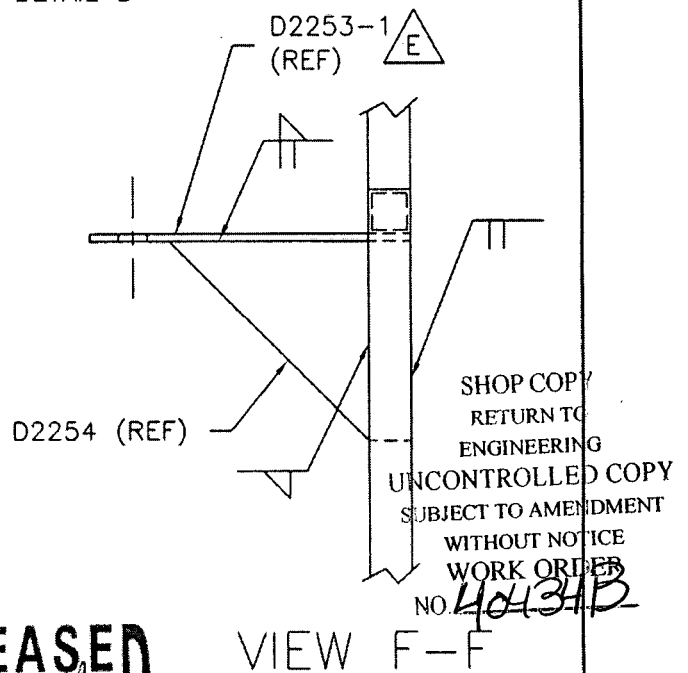
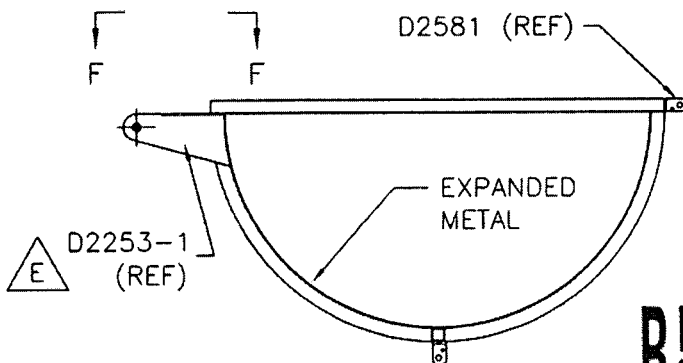
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| DATE 05.11.10 | TITLE BASKET ASSEMBLY (206B) | | SCALE NTS |

VIEW A-ADETAIL DVIEW B-B

Pat 01.07.11
UNDER REVIEW
08.02.06
TUBING TO BE
CHANGED TO 0.065
WELD

VIEW F-FVIEW C-C

RELEASED
05.11.26

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Date: Friday, 11/07/2008 10:50:26 AM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 206B BASKET LID - UNDER REVIEW
 Job Number : 40434A
 Estimate Number : 11280
 P.O. Number :
 This Issue : 11/07/2008 S.O. No. :
 Prsht Rev. : NC Part Number : D2330043
 First Issue : 11/07/2008 Type : LARGE FAB ASSY Drawing Number : D2330 REVE
 Previous Run : 40149A Project Number : N/A
 Material :
 Due Date : 29/08/2008 Qty: 1 Um: Each
 Written By :
 Checked & Approved By : JULIE LECOCQ
 Comment : Est Rev: H 02.09.04 M304EX0.75-16F was M750-16FXS-S/S K
 J

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

✓ 1.0 M304TS0750W065 304 SQ Tube.75x.75x.065W



Comment: Qty.: 30.2568 f(s)/Unit Total: 30.2568 f(s)

3/4" x 3/4" x 0.063 wall 304/316 SS tubing.

Batch: M108550

SAD 08/07/28 (V)

2.0 LARGE FAB 1 0.05 At 03.07.11 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- Cut D2330-1-3-9 as per Dwg D2330

2-Drill hole in D2330-3 as per Dwg D2330

3-Deburr

SAD 08/07/28 (V)

3.0 D22321 Basket Hinge



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2232-1 HINGE

B39454

SAD 08/07/28

4.0 D2329 Label Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2329 Label Plate

B35686

SAD 08/07/28

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Friday, 11/07/2008 10:50:26 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B BASKET LID - UNDER REVIEW

Job Number: 40434A

Part Number: D2330043

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D23271

Spacer Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2327-1 Bushing B 40084

SL 08/07/28

6.0

D2581

Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2581 Mounting Chanel B 40086

SL 08/07/28

7.0

M304EX07516F

Expanded Metal Flat Stai



Comment: Qty.: 18.9000 sf(s)/Unit Total: 18.9000 sf(s)

Pick:

Qty Part Number Description Batch

18 sf M304EX0.75-16F Expanded Metal

M108474
M107051

SAD 08/07/28

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld as per Dwg D2330 using Welding Table and corner Jig

Deburr as required

A/R SS ROD Batch: A107051

SL 08/07/28

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 08-07-30

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/07/30

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Friday, 11/07/2008 10:50:26 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B BASKET LID - UNDER REVIEW

Job Number: 40434A

Part Number: D2330043

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

POWDER COATING

POWDER COATING



N/108523



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

1:30
400 °F = 2 coats
2:00

M-h 08/07/30

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FD 08/07/30 (D)

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: G-A

08/07/31 (D)

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/07/31 (D)

Job Completion



MK 08-023)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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NOTE: Date & initial all entries

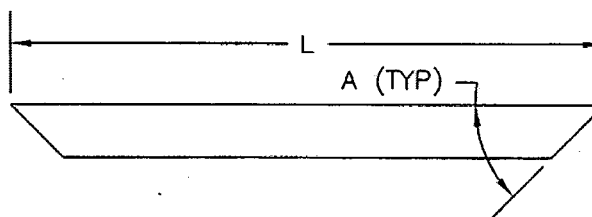
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| | | | |
|------------------------|-------------------------|--|------------------------|
| DESIGN KE | DRAWN BY MB | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED [Signature] | APPROVED [Signature] | DRAWING NO. D2330 | REV. E SHEET 1 OF 5 |
| DATE 05.11.10 | | TITLE BASKET ASSEMBLY (206B) SCALE NTS | |
| C | 96.05.23 | ADDED LATCH AND LABEL PLATE | |
| D | 99.09.14 | MODIFIED LATCH, REDREW | |
| E | 05.11.10 | D2253-1 WAS D2253 (NCR 533), ADDED MEMBERS TO LID FRAME, ADDED D2232-1/-3 & D2330-11 | |

| Qty -041 | Qty -043 | Part Number | Description | L | A |
|-------------|-------------|-------------|------------------------|-------|----|
| X | | D2330-041 | BASKET ASSEMBLY | | |
| | X | D2330-043 | LID ASSEMBLY | | |
| | | | | | |
| 1 | | D2012-107 | CLEVIS | | |
| 4 | | D2235-1 | RIB | | |
| | 2 | D2232-1 | HINGE | | |
| 2 | | D2232-3 | HINGE | | |
| 2 | | D2330-1 | FRAME | 84.00 | 45 |
| 2 | 2 | D2330-3 | FRAME | 25.50 | 45 |
| 1 | | D2330-5 | FRAME | 32.75 | 90 |
| 1 | | D2330-7 | FRAME | 24.25 | 90 |
| 1 | 2 | D2330-9 | FRAME | 24.00 | 90 |
| | 2 | D2330-11 | FRAME | 83.27 | 45 |
| | 2 | D2330-13 | FRAME | 23.63 | 90 |
| | 1 | D2330-15 | FRAME | 33.00 | 90 |
| 2 | | D2253-1 | LUG | | |
| 2 | | D2254 | GUSSET | | |
| | 1 | D2327-1 | BUSHING | | |
| 1 | | D2327-3 | BUSHING | | |
| | 1 | D2329 | LABEL PLATE | | |
| 4 | 2 | D2581 | MOUNTING CHANNEL | | |
| A/R | A/R | | 3/4-16F EXPANDED METAL | | |

NOTES:

- MATERIAL: AISI 304/316 SS 3/4 X 3/4 X 0.060 WALL SQUARE TUBE (REF. DART SPEC. M304TS0.075W(0.60))
- FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
- WELD PER DART QSI 004
- ALL DIMENSION ARE IN INCHES
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.



CUT SIZE DETAIL

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WORK ORDER

NO. 40434A

REV 08.07.11
UNDER REVIEW
08.08.05 PW
TUBING TO BE
CHANGED TO 0.065
WALL**RELEASED**
05.11.26

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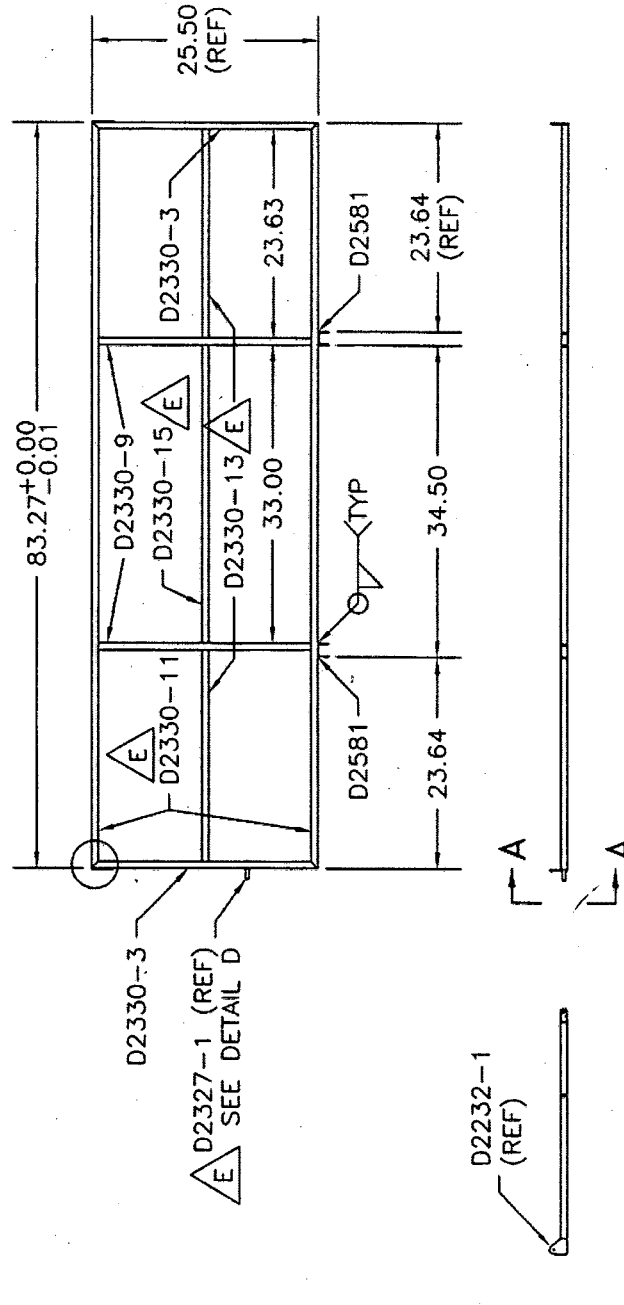
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| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D2330 | REV. E SHEET 2 OF 5 |
| DATE 05.11.10 | TITLE BASKET ASSEMBLY (206B) | SCALE NTS | |

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05.11.26

UNDER REVIEW

08.02.05 *[Signature]*
TUBING TO BE
CHANGED TO 11.065
WALL
[Signature]

03.07.11



D2330-043 LID FRAME

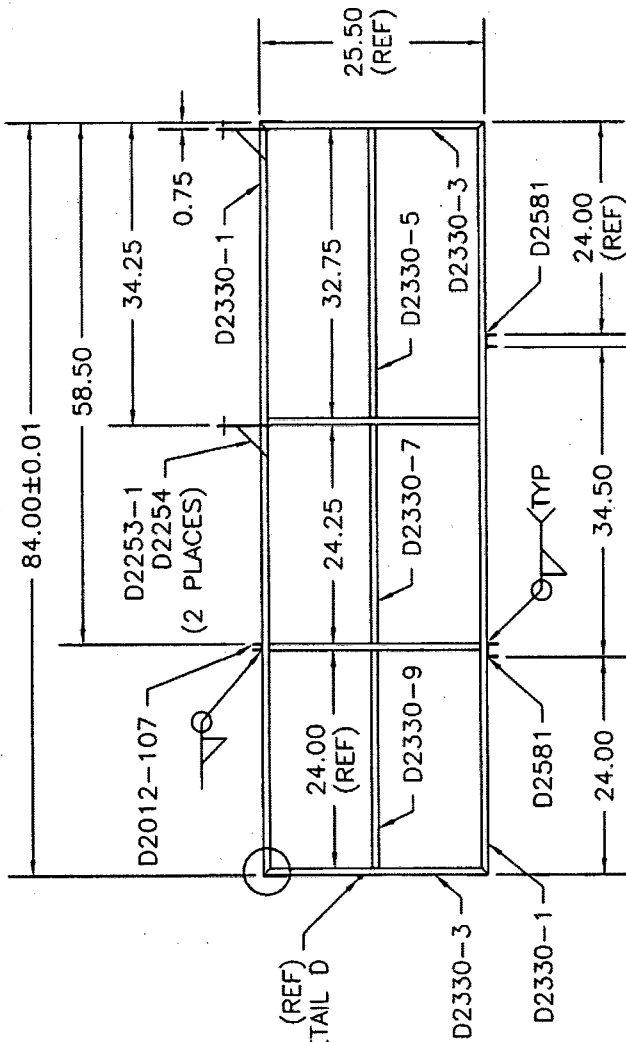
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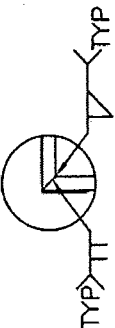
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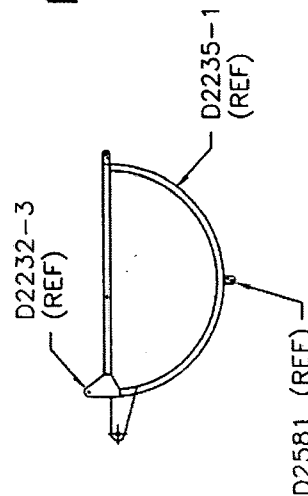
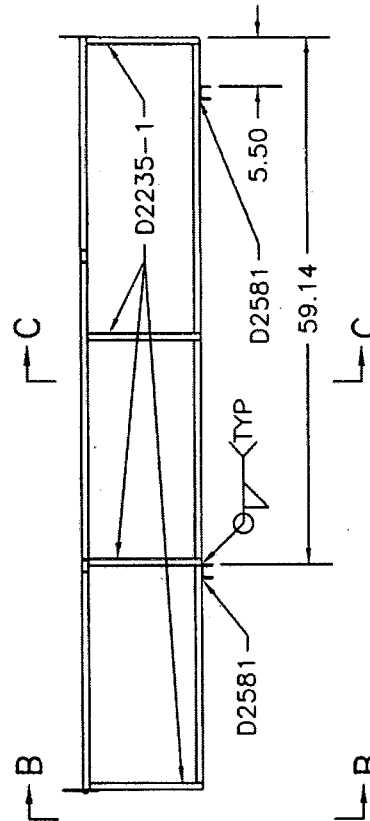
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| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D2330 | REV. E SHEET 3 OF 5 |
| DATE 05.11.10 | TITLE BASKET ASSEMBLY (206B) | | SCALE NTS |



WELD ALL JOINTS
AS SHOWN



RELEASED
05.11.26





08-07-11
UNDER REVIEW
08-02-05 PW
TUBING TO BE
CHANGED TO 0.065
WALL

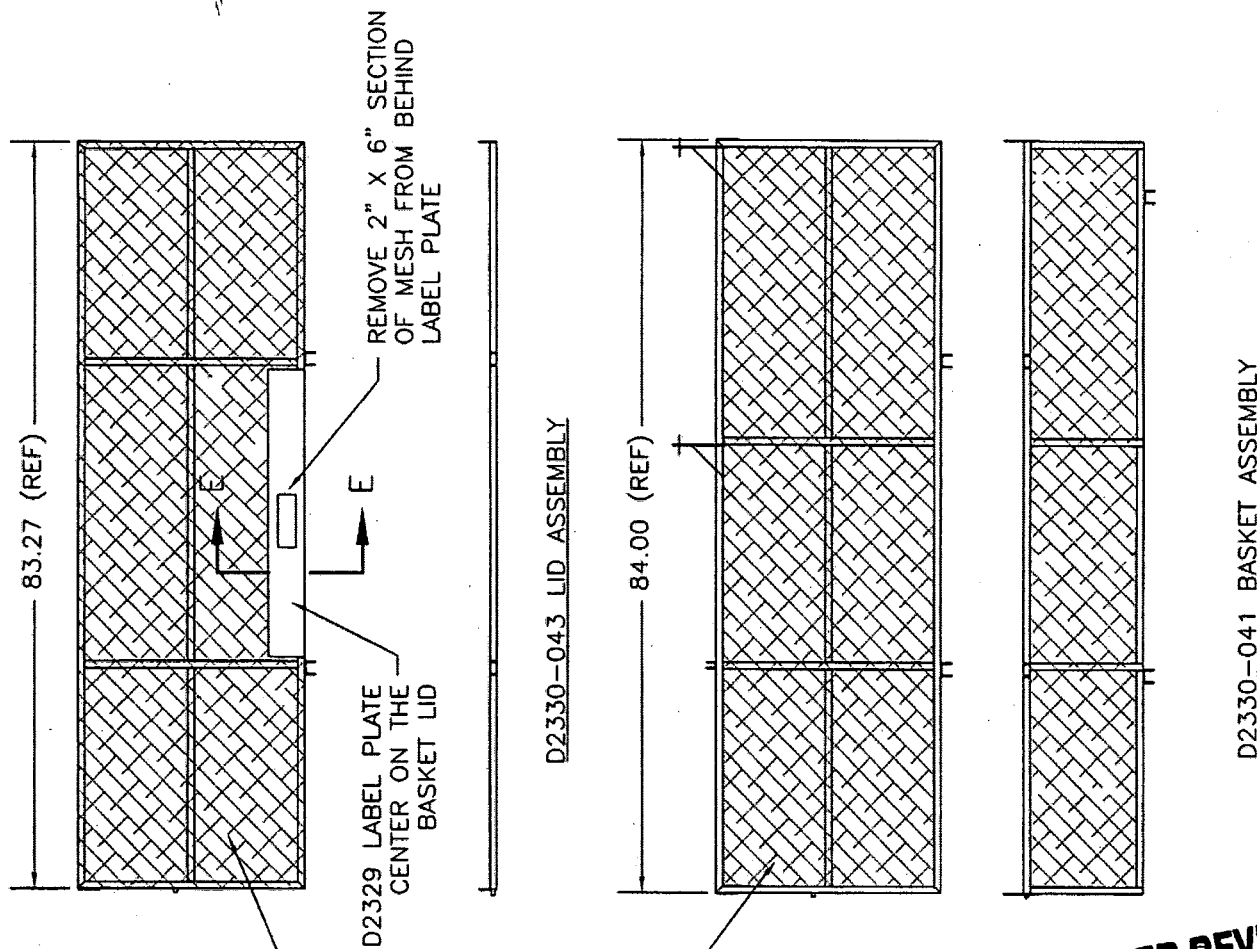
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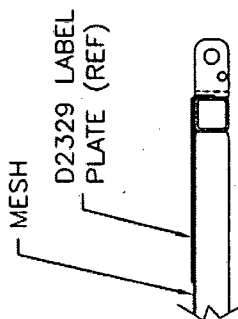
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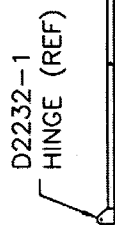
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| DATE 05.11.10 | | TITLE BASKET ASSEMBLY (206B) | SCALE NTS |



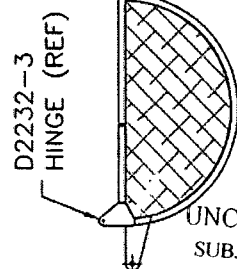
D2330-041 BASKET ASSEMBLY



SECTION E-E



SKIN WITH 3/4-16 F
EXPANDED SS, TACK
WELD EACH STRAND
END TO FRAME



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08.02.05
TUBING TO BE
CHANGED TO 0.045
WALL
08.07.11

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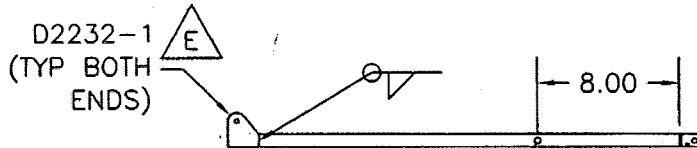
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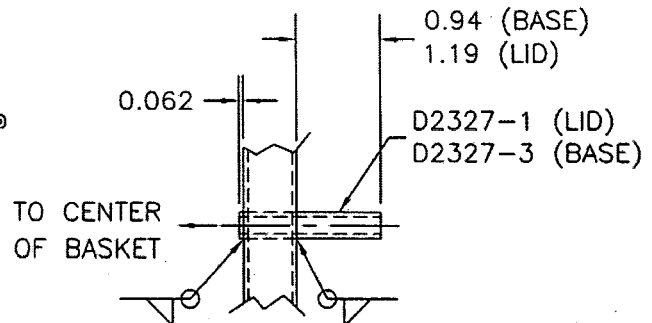
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| | | | |
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| DATE 05.11.10 | TITLE BASKET ASSEMBLY (206B) | | SCALE NTS |



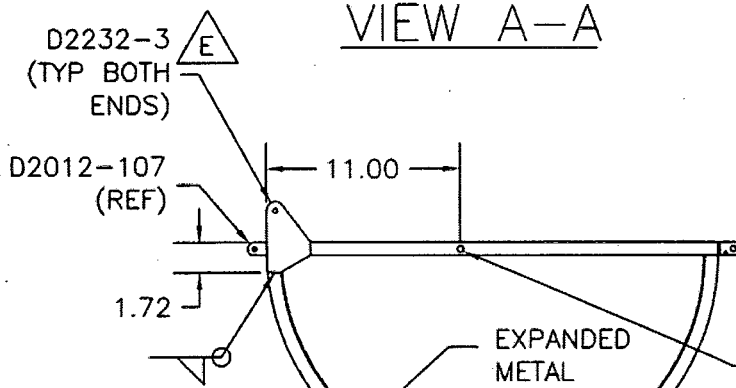
DRILL 3/8 HOLE AND
INSTALL D2327-1 PER
DETAIL D



TO CENTER
OF BASKET

VIEW A-A

DETAIL D



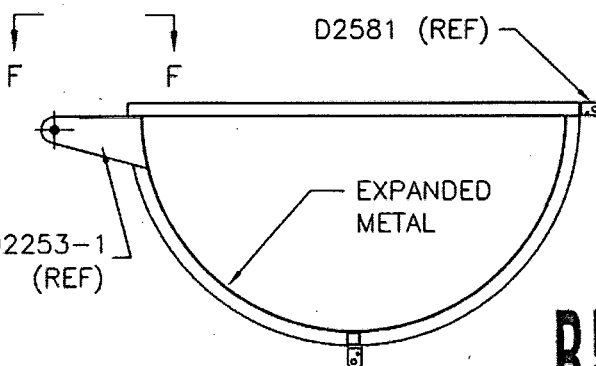
WELD D2581
WITH LARGE HOLE
ON THIS SIDE

D2581 (REF)

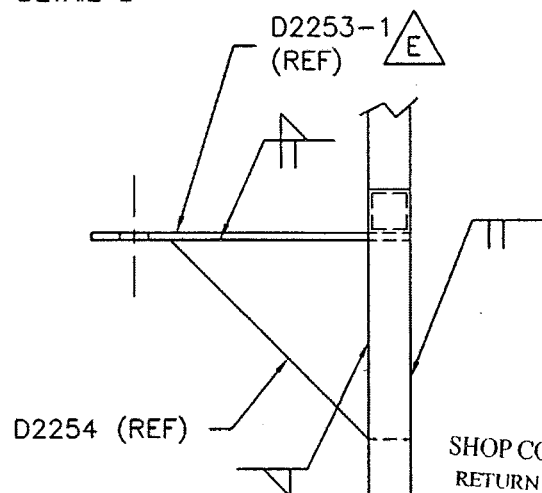
VIEW B-B

DRILL 3/8 HOLE AND
INSTALL D2327-3
PER DETAIL D

UNDER REVIEW
08.02.05
TUBING TO BE
CHANGED TO 0.065
WALL 08.07.11



VIEW C-C



VIEW NO. 2

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05.11.26

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